# Work Order ID 56783



*March 10, 2010 8:04:16 AM*

**Item ID:** D212-664-207TRN **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Crosstube Turning Detail

**Start Date:** 3/10/10 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 3/12/10 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start**

**QC:** **Date:** **SPC (Y/N):** **Date:** **Stop**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|

| Draw Nbr | Revision Nbr |
|---|---|
| D212-664-247 | Rev B |

100 0.00

Mori Seiki

MORI SEIKI CNC LATHE LARGE

Mori Seiki CNC Lathe Large

**Memo** 0.00

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA706
2-Turn first side as per Folio FA706
3- File transition lines smooth.

AWM/MB 10-03-11

110 QC1- Inspect dimensions to dimension sheet 0.00

QC

Quality Control

**Memo** 0.00

AWM/MB 10-03-11

120 0.00

Mori Seiki

MORI SEIKI CNC LATHE LARGE

Mori Seiki CNC Lathe Large

**Memo** 0.00

1-Turn second side as per Folio FA706
2- File transition lines smooth.
3-Remove sand and plugs

AWM 10-3-11

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 56783

*March 10, 2010 8:04:16 AM*



**Item ID:** D212-664-207TRN **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Crosstube Turning Detail

**Start Date:** 3/10/10 **Start Qty:** 1.00 **Cust Item ID:**

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**Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:**

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | QC1- Inspect dimensions to dimension sheet | 0.00 | | | | 1 | — | ~ | AWM 10-3-11 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 140 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 150 | Crosstubes Chemical Conversion | 0.00 | | | | | | | |
| HandFXtube | **Memo** | 0.00 | | | | | | | |
| Hand Finishing Crosstubes | | | | | | | | | |

S 10/02/12

MB 10-03-17

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 56783

*March 10, 2010 8:04:17 AM*



**Item ID:** D212-664-207TRN **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Crosstube Turning Detail

**Start Date:** 3/10/10 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 3/12/10 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:**

**QC:** **Date:** **SPC (Y/N):** **Date:**

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | | 0.00 | | | | | | | |
| Packaging | Packaging | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| | Identify and stock in kanban rack<br>Location: X-tube cell | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

qm 10-03-17

(K) 8 MB 10-03-17

10.03.17

MF 10-3-17

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
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| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Pieklist Print



*March 10, 2010 8:04:04 AM*

**Work Order ID:** 56783

**Parent Item:** D212-664-207TRN

**Parent Item Name:** Crosstube Turning Detail

**Start Date:** 3/10/10 **Required Date:** 3/12/10

**Comments:** IPP Rev:A New Issue 08-03-06 DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified DD

**Start Qty:** 1.00 **Required Qty:** 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D6008-132 | | Manufactured | No | | | 110 | Each | 6.0000 | 1.0000 | MB | 10-03-11 | |

Crosstube extrusion

| Warehouse Location | Loc Qty | Loc Code |
|---|---|---|
| Main Warehouse | | |
| LG | 6 | |
| 50892 | 6 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 56783 |
|---|---|---|
| | | |
| **Description:** Crosstube Assembly (205/212 Low Aft) | Part Number: | D212-664-247 |
| | | |
| **Inspection Dwg:** D212-664-247 **Rev:** ~~A~~ B 10.03.10 | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|---|
| SIDE A | 0.438 | +/-0.010 | .438 | ✓ | | | |
| | 2.680 | +0.005/-0.000 | 2.680 | ✓ | | | |
| | 2.680 | +0.005/-0.000 | 2.680 | ✓ | | | |
| | 2.687 | +0.005/-0.000 | 2.687 | ✓ | | | |
| | 2.802 | +0.005/-0.000 | 2.802 | ✓ | | | |
| | 2.906 | +0.005/-0.000 | 2.908 | ✓ | | | |
| | 3.009 | +0.005/-0.000 | 3.009 | ✓ | | | |
| | 3.112 | +0.005/-0.000 | 3.112 | ✓ | | | |
| | 3.250 | +0.005/-0.000 | 3.250 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 0.438 | +/-0.010 | 0.438 | ✓ | | | |
| | 2.680 | +0.005/-0.000 | 2.680 | ✓ | | | |
| | 2.680 | +0.005/-0.000 | 2.680 | ✓ | | | |
| | 2.687 | +0.005/-0.000 | 2.687 | ✓ | | | |
| | 2.802 | +0.005/-0.000 | 2.802 | ✓ | | | |
| | 2.906 | +0.005/-0.000 | 2.908 | ✓ | | | |
| | 3.009 | +0.005/-0.000 | 3.009 | ✓ | | | |
| | 3.112 | +0.005/-0.000 | 3.112 | ✓ | | | |
| | 3.250 | +0.005/-0.000 | 3.250 | ✓ | | | |
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| | | | | | | | |
| | | | | | | | |
| | 128.27 | +/-0.030 | 128.270 | ✓ | | | |

| Measured by: | AW AP / MS | Audited by: | S | Prototype Approval: | N/A |
|---|---|---|---|---|---|
| Date: | 10-03-11 | Date: | 12/07/12 | Date: | N/A |

| Rev | Date | Change | | Revised by | Approved |
|---|---|---|---|---|---|
| A | 08.11.07 | New Issue | (P/O D212-664-207) | KJ/EC | |

| Item | Qty -247 | Qty -247B | Part Number | Description |
|---|---|---|---|---|
| 1 | X | | D212-664-247 | CROSSTUBE ASSEMBLY (205/212 LOW AFT) |
| 2 | | X | D212-664-247B | CROSSTUBE ASSEMBLY (214 LOW AFT) |
| 3 | 1 | 1 | D6008-132 | CROSSTUBE |
| 4 | 2 | 2 | D2940-1 | SUPPORT |
| 5 | 4 | 4 | D3595-063-530 | RUBBER CUSHION |
| 6 | 2 | 2 | D3660-1 | CUFF |
| 7 | 4 | 4 | MS21920-28 | CLAMP (OR MS21920-30) |
| 8 | 44 | 44 | CR3212-4-06 | RIVET (OR M7885/3-4-06) |
| 9 | A/R | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
| 10 | A/R | A/R | SIKAFLEX-241/-291 | SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT) |

**GENERAL NOTES:**

1) MATERIAL: MANUFACTURED FROM D6008-132
   FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
   PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)
   D212-664-247B = 36.6 lbs (PER IIN-D212-664)
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

wo 56783

RELEASED
2009 -10- 7 9

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| B | REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS; ADD -247B (ZN C4-2, D5-2) | RF | 09.09.30 |
| A | NEW ISSUE | CP | 07.07.07 |

| | | | |
|---|---|---|---|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D212-664-247 | SHEET 1 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CROSSTUBE (205/212 LOW AFT) | NTS |
| DATE | 09.09.30 | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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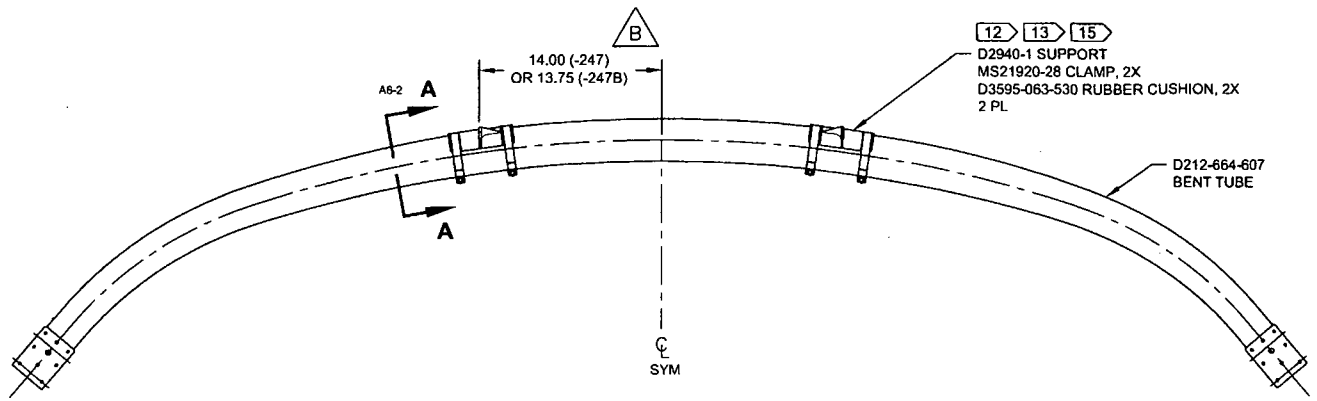
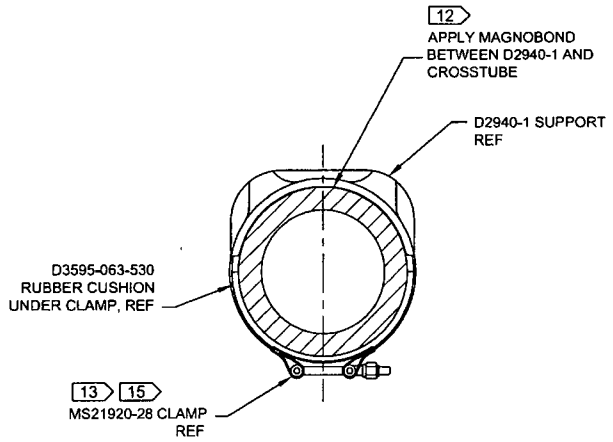
**NOTE:** Date & initial all entries




**D212-664-247/-247B ASSEMBLY DETAIL** B




**SECTION A-A** D6-2
SCALE 4X

RELEASED
2009 -10- 29

| | | | |
|---|---|---|---|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D212-664-247 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CROSSTUBE (205/212 LOW AFT) | NTS |
| DATE | 09.09.30 | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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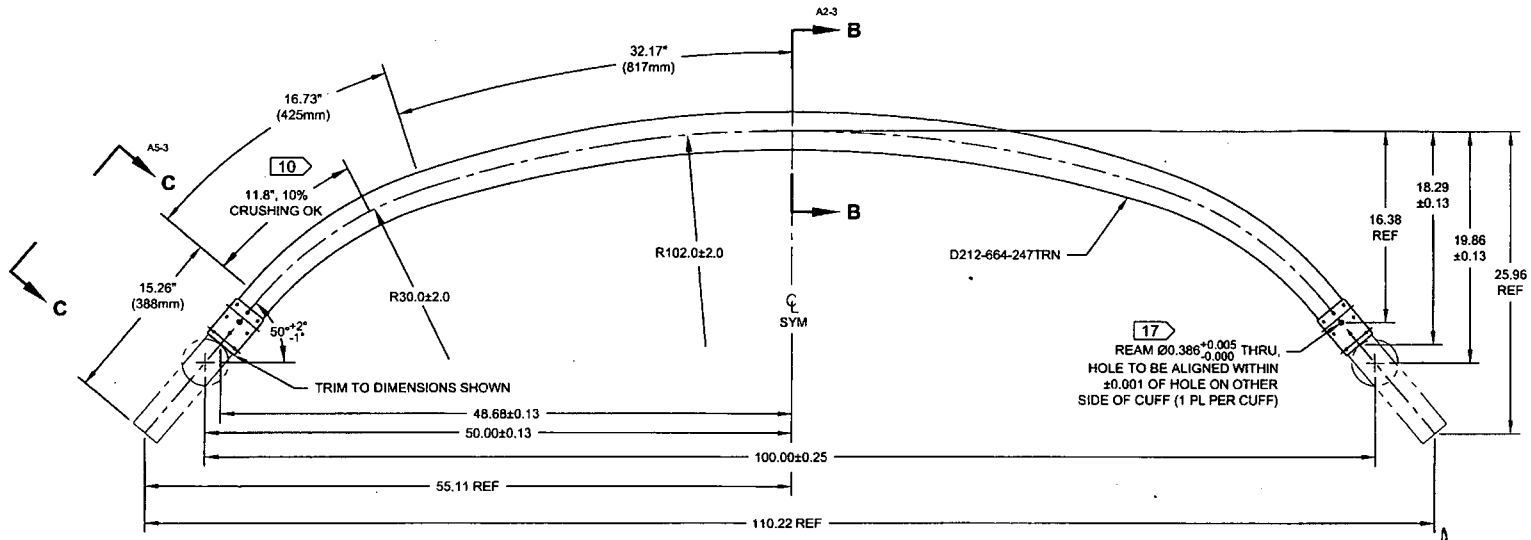
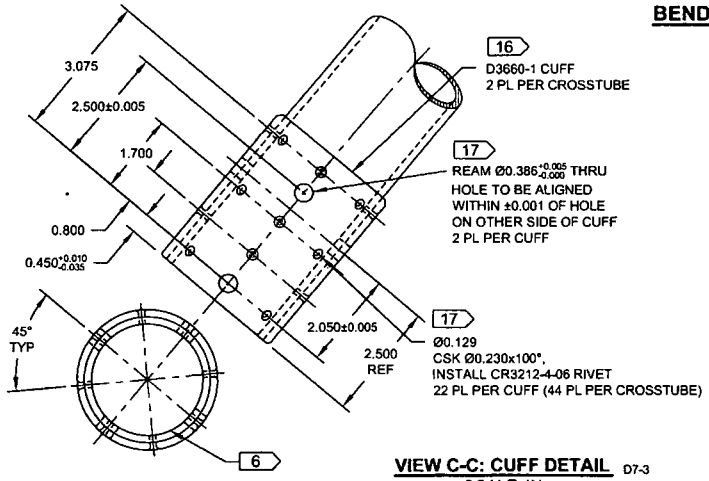
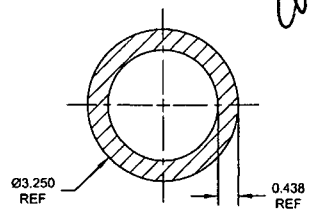
**NOTE:** Date & initial all entries




**D212-664-607**
**BENDING AND DRILLING DETAIL** 10 B




**VIEW C-C: CUFF DETAIL** D7-3
SCALE 4X




**SECTION B-B** D4-3
SCALE 4X

RELEASED
2009 -10- 29

| | | |
|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | | DRAWING NO. REV. B |
| MFG. APPR. | | D212-664-247 SHEET 3 OF 4 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | CROSSTUBE (205/212 LOW AFT) NTS |
| DATE 09.09.30 | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
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| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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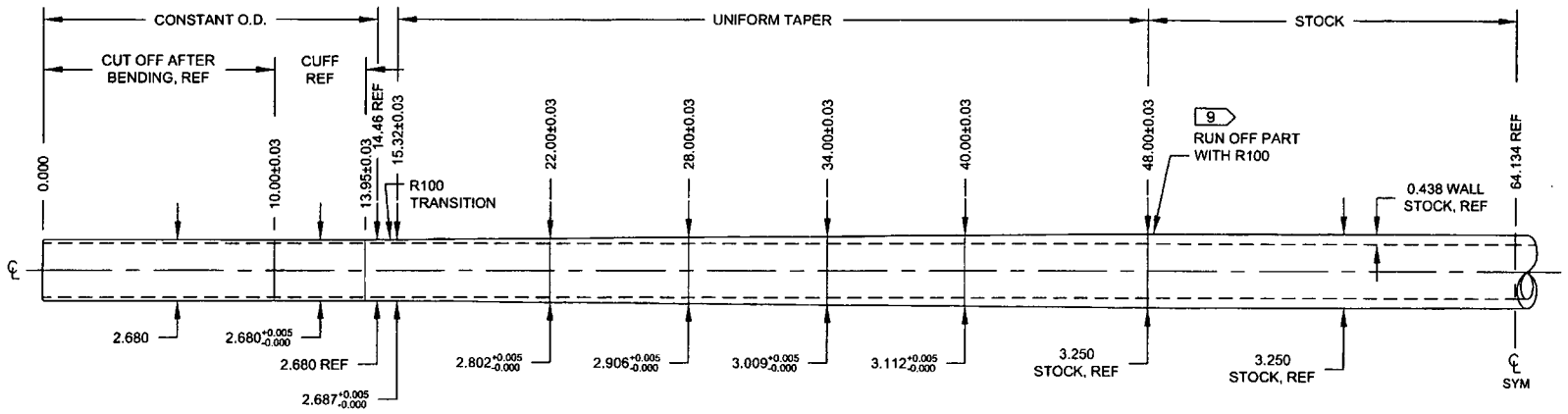
**NOTE:** Date & initial all entries




**D212-664-247TRN**
**TURNING DETAIL**

RELEASED
2009 -10- 29

| | | | |
|---|---|---|---|
| DESIGN | | **DART AEROSPACE LTD** | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D212-664-247 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CROSSTUBE (205/212 LOW AFT) | NTS |
| DATE | 09.09.30 | | |

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries